

Date: Friday, 30/11/2007 1:01:37 PM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 36085  
Estimate Number : 12812  
P.O. Number :  
This Issue : 30/11/2007 S.O. No. :  
Prsht Rev. : NC  
First Issue : / / Type : MACHINED PARTS  
Previous Run : 32832  
Written By :  
Checked & Approved By :  
Comment : est rev A new issue 07.03.28 EC  
est rev B released, changed mat'l EC

Drawing Name : BRACKET  
Part Number : D3610041  
Drawing Number : D3610 REV.A  
Project Number : N/A  
Drawing Revision : A  
Material :  
Due Date : 07/12/2007

Qty: 21.20 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4140NB1500X15000 AISI 4140 Steel Bar



Comment: Qty.: 0.5775 f(s)/Unit Total : 11.5500 f(s)  
AISI 4140 Steel Bar

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 6.600 " long

Batch M106451 X20

M104993X2

Qnd 07/12/05

(20)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: A

2-Deburr per dwg D3610

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-C'SINK AS PER DWG D3610

mf 07-12-07

(17)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mf 07/12/07

(17)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642

mf 07/12/07

(17X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-12-07

10.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
Nutplate  
Batch: M18057

-2 in computer

AS 07/12/07

X17

11.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)  
RIVET  
batch: M102404

AS 07/12/07

(X17)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Rivet Nut Plate as per Dwg D3610

mf

07-12-07

(17)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

mf 07/12/07

(X17)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 8/12/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/11/2007 1:01:37 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 36085

Part Number: D3610041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57247A

67/12/17 (17)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(17)

Comment: FINAL INSPECTION/W/O RELEASE

72 07/12/13

Job Completion



6 07-1207



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

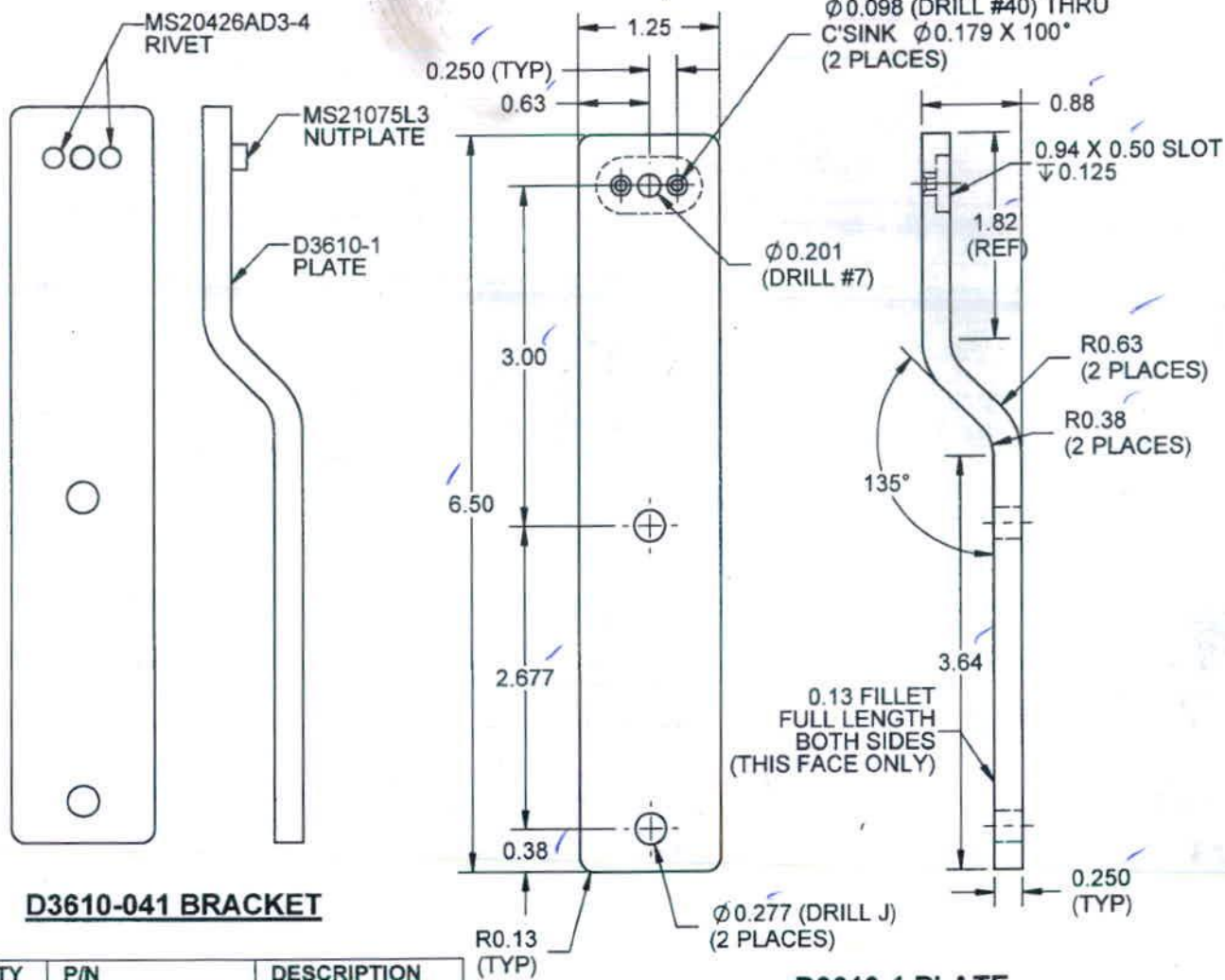
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3610</b>	REV. A SHEET 1 OF 1
DATE <b>07.04.20</b>	TITLE <b>BRACKET</b>		SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	

**D3610-041 BRACKET**

QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

**D3610-1 PLATE****RELEASED**07.04.25 *[Signature]***D3610-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

**D3610-1 NOTES:**

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 36085
Description: bracket		Part Number: D361004
Inspection Dwg: D3610	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+ .030	1.247	✓			
.250	+ .010	.250	✓			
Ø .098	+ .008 - .001	.100	✓			
.63	+ .030	.624	✓			
Ø .201	+ .005 - .001	.204	✓			
6.50	+ .030	6.498	✓			
3.00	"	2.998	✓			
2.677	+ .010	2.677	✓			
.38	+ .030	.373	✓			
5.130	+ .030	.130	✓			
.277	+ .005 - .001	.279	✓			
.88	+ .030	.879	✓			
.94X.50	+ .030	.940X.501	✓			
1.82	"	1.827	✓			
3.64	+ .030	3.648	✓			
.250	+ .010	.250	✓			
1350	+ 1/2°	1350	✓			
↓ .15	+ .010					

Measured by: J.L.	Audited by: J.F.	Prototype Approval:
Date: 07/12/06	Date: 07/12/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

